

Date: Friday, 03/04/2009 10:19:37 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HAT BIN 206 A/B W/LITTER
 Job Number : 46919
 Estimate Number : 13690
 P.O. Number :
 This Issue : 03/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D38243 KIV. MF 09-06-1
 Drawing Number : D3824 PRELIMINARY
 Project Number : IN0002
 First Issue : / / Type : THERMOFORMING Drawing Revision : B PRELIMINAR
 Previous Run : 43952 Material :
 Due Date : 10/04/2009 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : JUD 09.04.03
 Comment : Est. Rev. A 08/123/08 New Issue DL
 Rev. B Dwg. Update 09/02/09 DL verified by:DD

PRELIMINARY ISSUE

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MKYD6185S082362015 6185 KYDEX .080"



Comment: Qty.: 11.3747 sf(s)/Unit Total : 22.7493 sf(s)

6185 Kydex .080" .125"

M410426

09/04/10

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/04/10 (X)

3.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/04/10 (X)

4.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3824-3 and folio FTA 034 using tool DT 9448

Dwg. Rev. D

Folio Rev. B

BB 09/04/10 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09/04/10	1.0.	CHANGE MAT FROM MKYD61855080P 362015 TO MKYD61855125P 362015	W.R.	09/04/10	1			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 03/04/2009 10:19:37 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN 206 A/B W/LITTER

Job Number: 46919

Part Number: D38243

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

~~BR~~ 09/04/10

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DL 09/04/10

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



POSITIVE RECORD

EFFECTIVE

09/04/10

AUTH



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

RELEASED

DATE

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Could not
delete w/o DO
closed it @

MF
09-06-22

Dart Aerospace Ltd

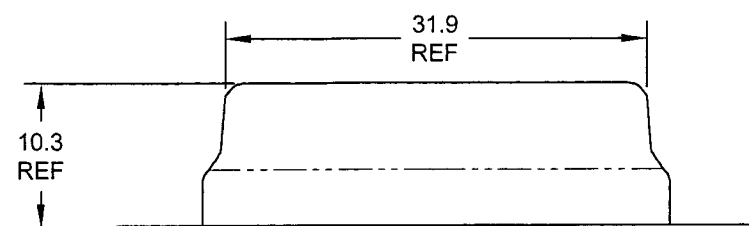
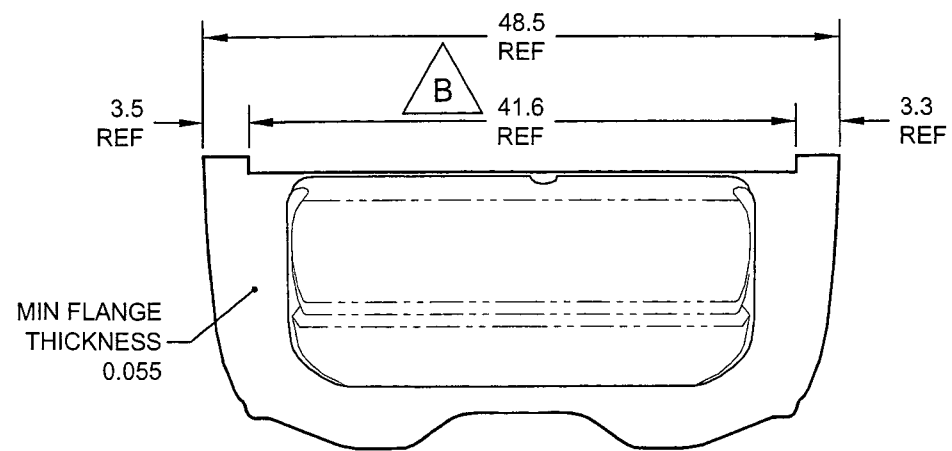
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

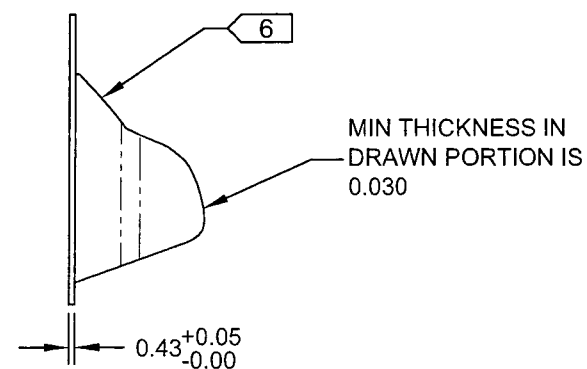
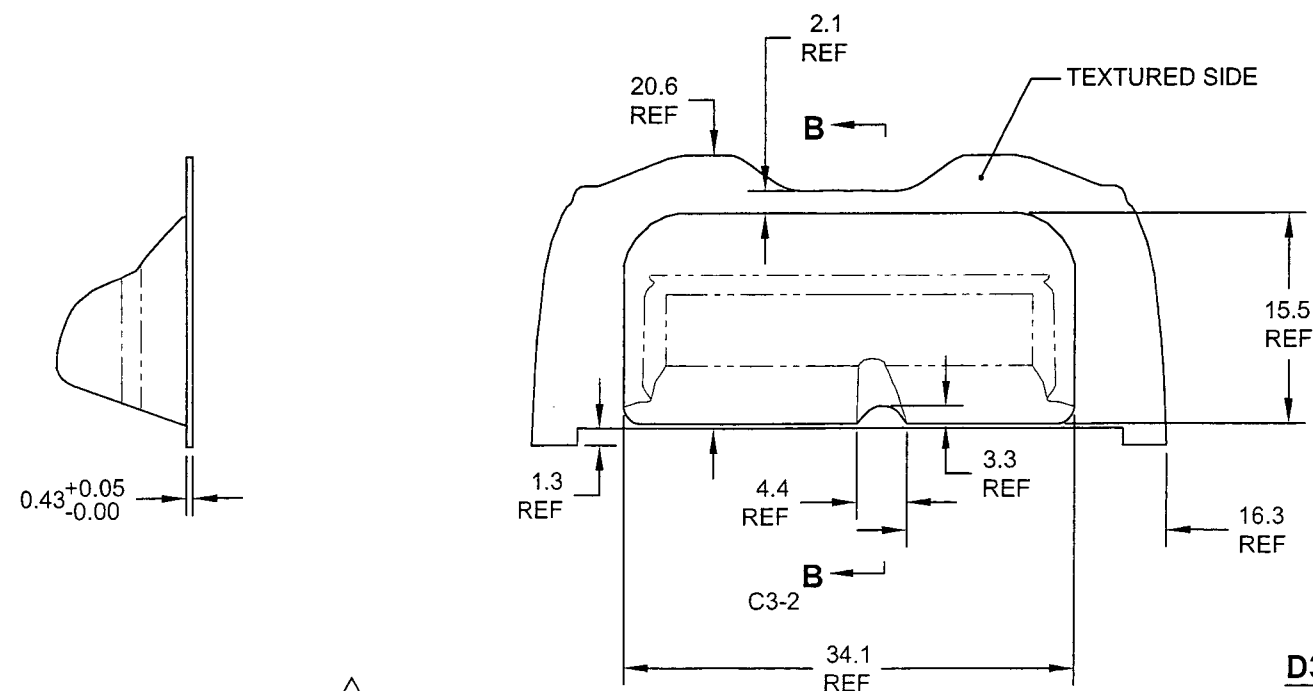
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



A6-2
SECTION B-B
SCALE 2X



D3824-3 HAT BIN
(BELL 206 A/B, LITTER KIT COMPATIBLE)

NOTES:

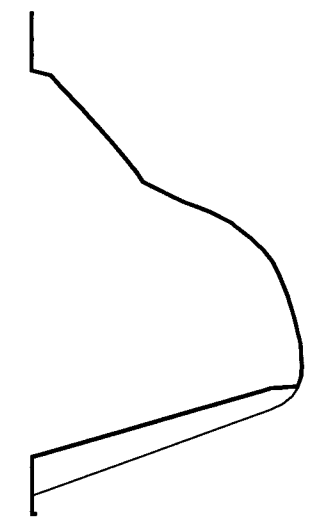
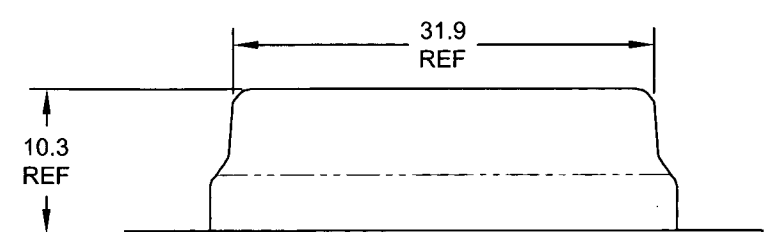
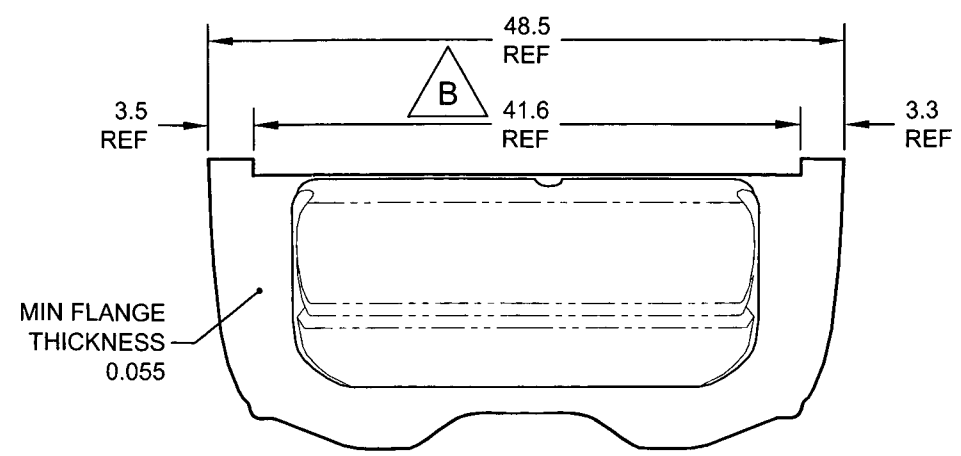
- 1) MATERIAL: KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.125-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3824-3" USING VIBRATING STYLUS
- 7) WEIGHT: 5.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9448 PER DART QSI 022. TRIM PER MOLD

SHOP COPY
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WORK ORDER
NO. 4698

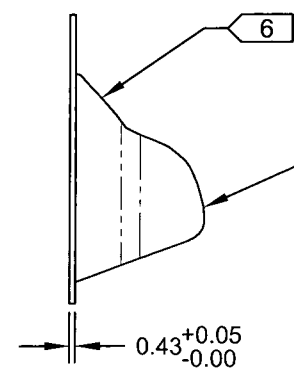
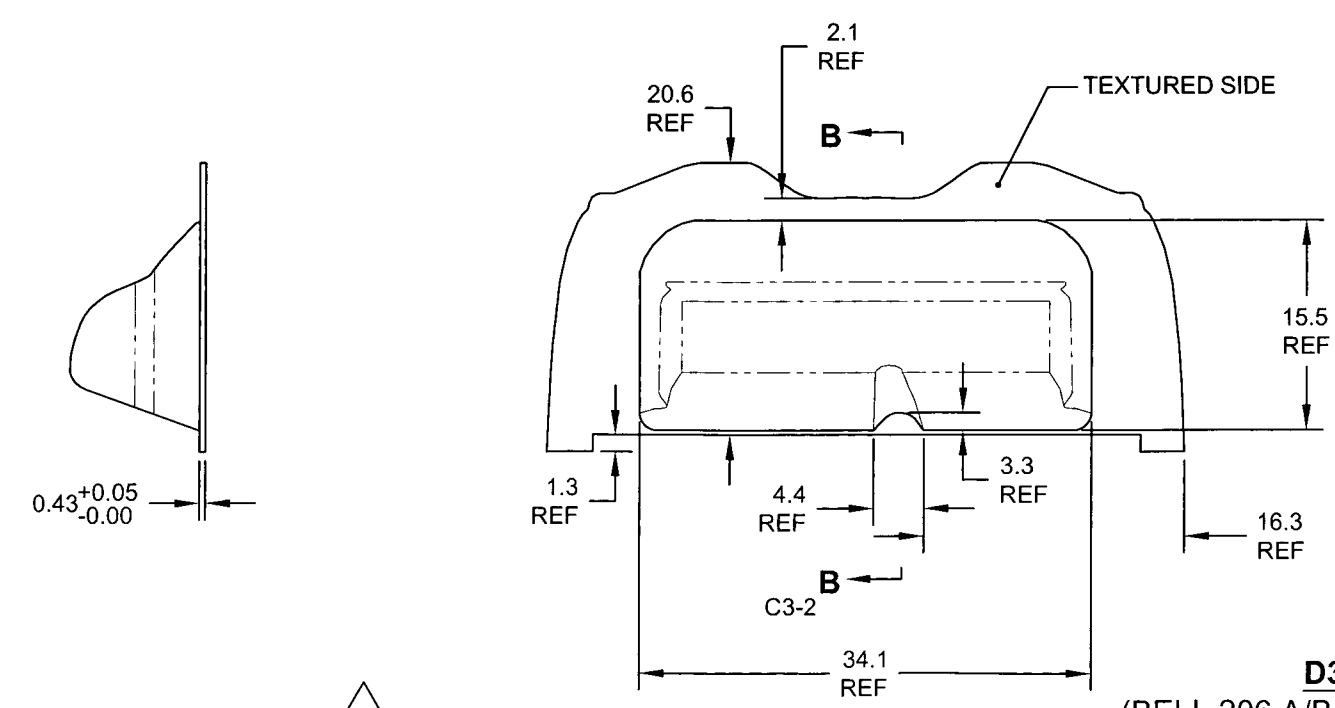
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09-04-02

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MFG. APPR.		D3824	SHEET 2 OF 2
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SECTION B-B
SCALE 2X



D3824-3 HAT BIN
(BELL 206 A/B, LITTER KIT COMPATIBLE)

- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (REF DART SPEC MKYD6185S.125-P3-62015)
 - 2) FINISH: NONE
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**PRELIMINARY
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